

Work Order ID 128246

128246

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Tuesday, January 13, 2015 1:35:08 PM

Item ID: D4131-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Base
 Start Date: 1/13/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4131	C								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>C</u> Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(12) _____ 01/15/16

(12) _____ 01/15/16

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N900040100

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

Start Date: 1/13/2015 **Start Qty:** 10.00

Required Date: 1/20/2015 **Req'd Qty:** 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Insp.
Stamp**

QC8- Inspect parts - second check

0.00

120

0.00

OC

Memo

Quality Control

130

Bend as per dwg

0.00

130

0.00

Brake NC

Memo

Brake NC

DAS
30
9-89

17

DAS
38
9-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

0.00

OC

Memo

Quality Control

~~JAN 28 2015~~

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

2x 50 15-01-28

15/1/29 JF

15-1-29

Picklist Print

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Work Order ID: 128246

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Parent Item: D4131-3

D4131-3

Parent Item Name: Base

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	SF	349.2443	0.1614	2			
M304S18GA									**		<u>01/15/01/16</u>		
304/316 .050 Sheet													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	349.2443	
124572	23	
125552	22	
M126647	24.6112	
M128254	22.1607	
M128435	27	
M128864	33	
M129530	55	
M130345	38	
M130923	104.4724	

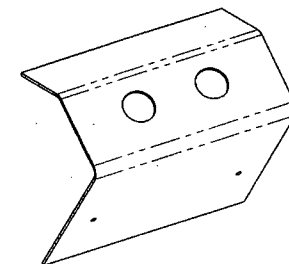
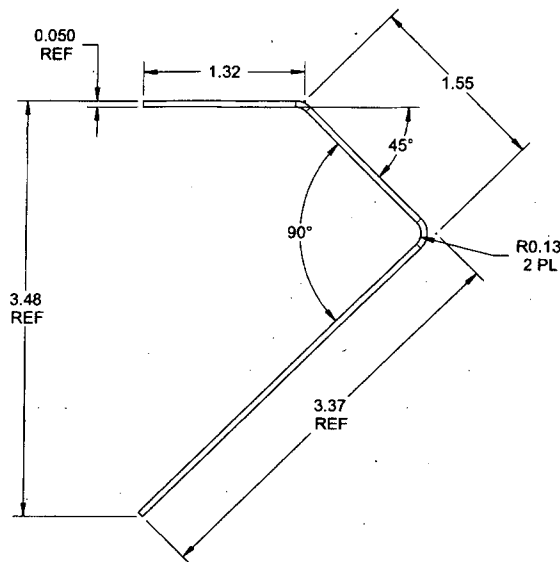
2.8923

DART AEROSPACE LTD		Work Order:	128246
Description: Base		Part Number:	D4131-3
Inspection Dwg: D4131	Rev: B		Page 1 of 1

[illegible]

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ	
B	12.03.08	Dimensions updated per Dwg Rev B	KJ	
C	12.05.15	Dimensions added per Dwg Rev B	KJ	

COPY
 128246-MW
 15-01-14

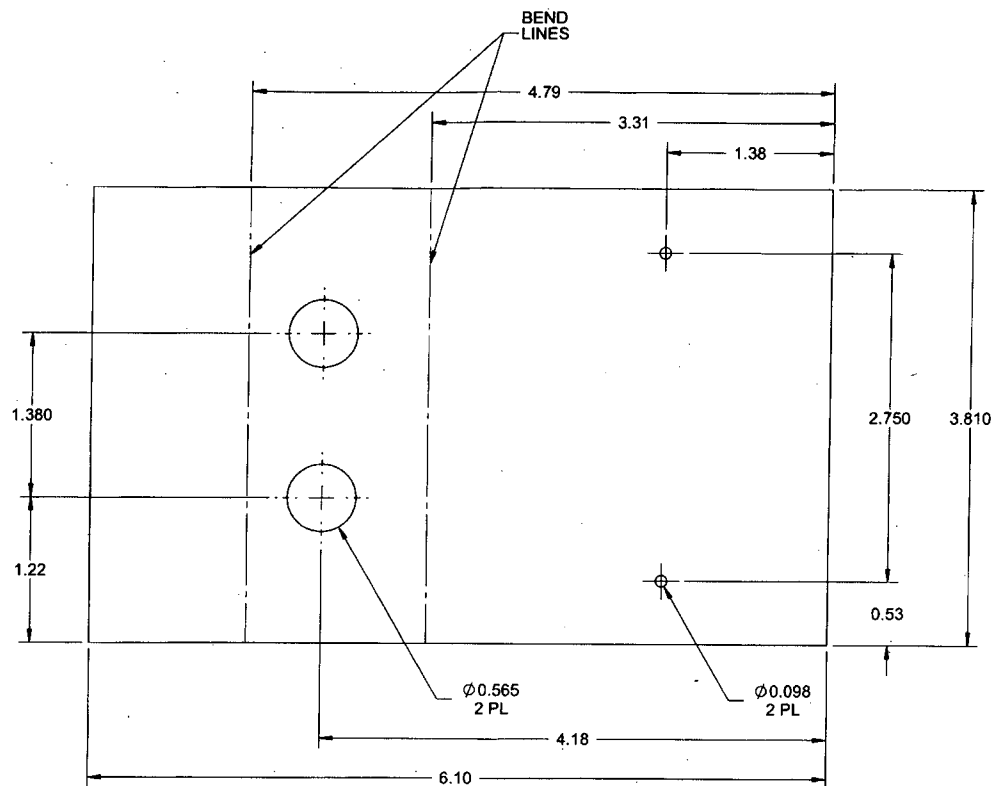


D4131-3 BASE
 (MAKE FROM D4131-3F FLAT PATTERN)

RELEASED
 2014-10-20

- NOTES:**
- 1) MATERIAL: MAKE FROM D4131-3F FLAT PATTERN
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

APPROVED	DESIGN	RF	DART AEROSPACE USA, INC.	
	DRAWN	RF	KENT, WA	
	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4131	SHEET 6 OF 10
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	MANIFOLD ASSEMBLY	NTS
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D4131-3F FLAT PATTERN

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
 PER MIL-S-5059
 OR AMS 5513 (304)
 OR AMS 5524 (316)
 OR ASTM A240
 OR ASME SA240
 PER DART SPEC. M304S18GA

2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
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RELEASED
 2014-10-20
mm

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	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4131	SHEET 7 OF 10
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